

Work Order ID 50216

July 14, 2009 1:00:15 PM



Page 1

Item ID: D3793-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Wearshoe

Start Date: 7/15/09 Start Qty: 10.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *09-07-15* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3793	Rev A
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100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3793

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

(11) IB 9-7-08

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

(11) IB 9-7-08

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

z> S o r l u b g (11) 9-7-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50216

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Page 2

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Setup Start

Stop

Start Date: 7/15/09 Start Qty: 10.00

Required Date: 7/15/09 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start




QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00							
Brake NC	Memo 1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs	0.00							<i>8/20/07/30</i> (11)
140  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							<i>=> 8 02/07/30</i> (41) ϕ
150  Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powder Coating	M109091 Memo START TIME: 8:10AM OVEN TEMPERATURE: 320°F FINISH TIME: 8:40AM	0.00							<i>=> 09-07-31</i> (X11) <i>LY</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 09-07-31 (11)

170

Identify as per dwg & Stock Location: FP-18

0.00



Packaging

Memo

0.00

Packaging

W 09-04-31 (X11)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

209-08-05
D

31-07-09
W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 1:00:14 PM

Page 1

Work Order ID: 50216

Parent Item: D3793-3RevA

Parent Item Name: Wearshoe

Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	111.7100	13.5032	1,35032 / unit		
										x 11 14.85352		

304/316 .040 Sheet

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

111.71

110076

32.79

111571

78.92

111571 H3 9-7-09

(11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

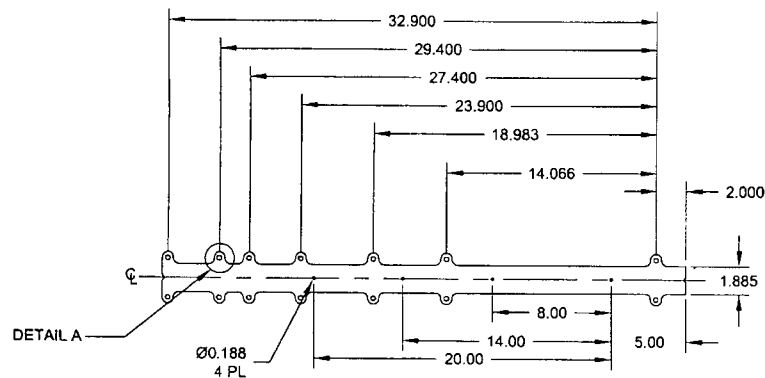
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QA: N/C Closed: _____ Date: _____

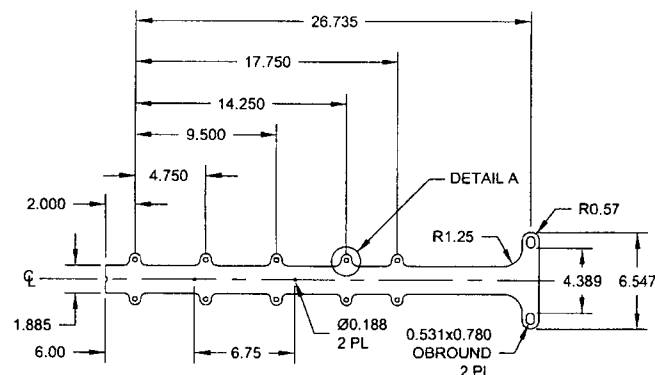
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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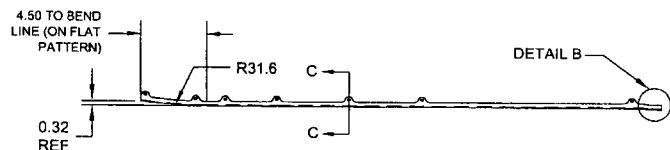
8 7 6 5 4 3 2 1



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

RELEASED
08-05-14

NOTES:

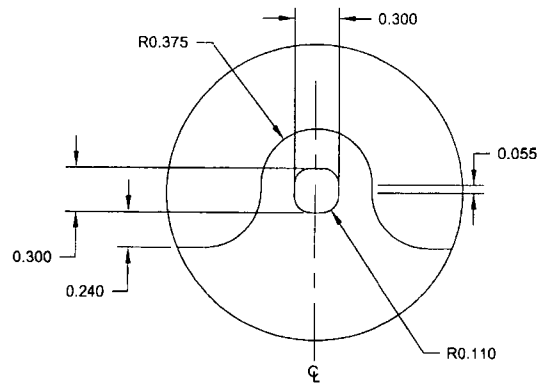
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 50216
MF 09-07-15

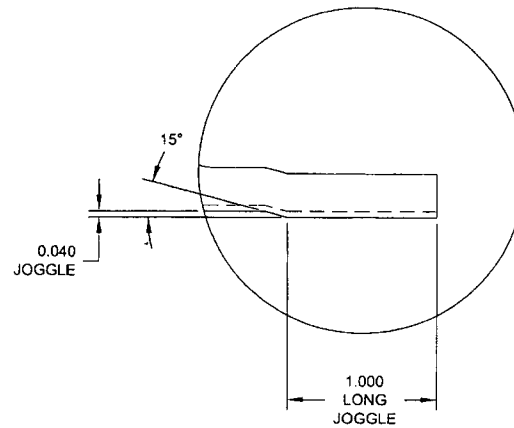
REV.	NEW ISSUE	DESCRIPTION	PH	08.05.14
DESIGN	PH	DART AEROSPACE USA, INC		
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CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3793	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		WEARSHOE	NTS	
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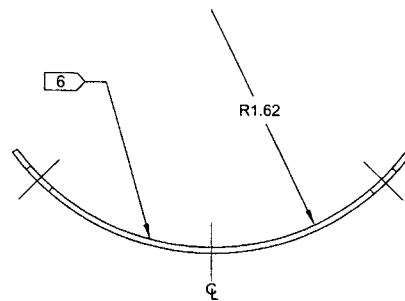
D
C
B
A



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

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08-05-14

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MFC 09-07-15

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MFG. APPR.	PH	D3793	SHEET 2 OF 2
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8 7 6 5 4 3 2 1